

5422

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBEM652V3002101-M-9
Job Sheet 177796

Part No: RBEM652V3002101-M-9 Job Qty: 6 ea
Part Name: Bar Handle Nut
Part Weight: 0 lbs Status: At Planning Priority: Medium
Job Created: 5/17/18 Job Tracking No:
Due Date: 7/23/18 Created By: Logan David
Type: SOLD Description:
Note: DWG RBEM652V3002101-M Rev D IPP Rev A 18.04.02 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	7/23/18	7/23/18	0.00 0.00	Start Up Machining-3		
110	Mill Conv	6 pcs	7/23/18	7/23/18	0.00 2.00	Mill Conv 2		
120	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC2 Machining-4		
130	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC8 Machining-4		
150	Outsource	6 pcs	7/23/18	7/23/18		GRO002-VC	10	
160	Packaging	6 pcs	7/23/18	7/23/18	0.00 0.00	Packaging2		
170	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC6		
180	Packaging	6 pcs	7/23/18	7/23/18	0.00 0.00	Packaging3-1		
190	QC21-SA	6 Ea	7/23/18	7/23/18	0.00 0.00	QC21		

Part Op 110 - 1-Machine as per DWG. Drill hole section D-D and 0.128 hole. 2-Debur
Descriptions: 150 - Issue P/O to Groupe Altech; PO 0-1899 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CLM-10-BHN	Ball Handle Nut	6 Ea (1 ea)	90-Start up Operation	5063336 (4x) 5093437 (4x)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CLM-10-BHN	6	11	0

Part Specifications

Specifications could not be found.



Container No: S107317



Part: RBEM652V3002101-M-9

Job No: 177796

Serial No/Batch: S107317

Revision: D

Inspector:

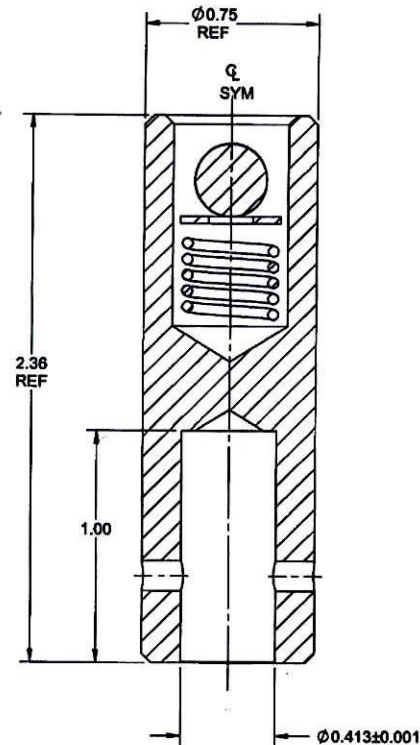
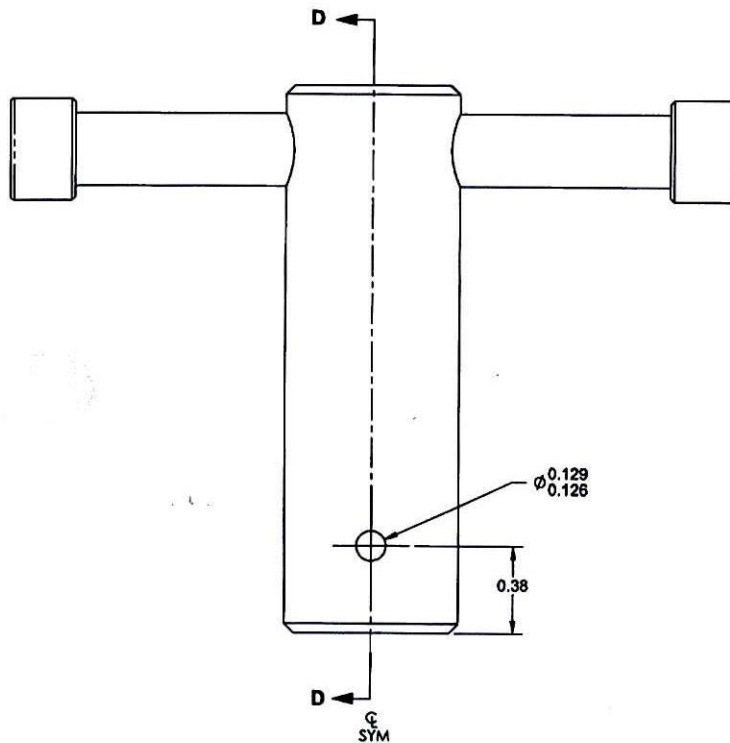
Exp Date:

Instructions:

Date: 08/31/18

Dart Aerospace Ltd.
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CANADA
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Printed 5/17/18 3:36 PM dart.logan.david



SECTION D-D

RBEM652V3002101-M-9 BAR HANDLE NUT

NOTES:

- 1) MATERIAL: CARR-LANE#CLM-10-BHN
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	REV. D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 7 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/28/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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Aug. 27 5 1hr 3/4
~~8-8-18~~

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040899**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040899

PO Date: 8/30/18

Due Date: 9/6/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181846-A	RBE350A94-3701-00-03	6" Main Rotor Rigging Tool (Dual) -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	9/6/18	1 pcs	0 pcs	1 pcs	\$120.00/pcs	\$120.00



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PURCHASE ORDER

PO040899

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181727	RB AN8516-1-PO	1/2" Drive Adjustment Spanner -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/6/18	3 pcs	0 pcs	3 pcs	\$8.50/pcs	\$25.50
Line Item Note ** rush part, please prioritize this part over others ** 3 x SEP 07 2018											
3	182724	RBT18520-5	Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	2 pcs	0 pcs	2 pcs	\$2.25/pcs	\$4.50
2 x SEP 07 2018											
4	181556	RBT18520-9	Extension -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$4.35/pcs	\$34.80
8 x SEP 07 2018											
5	181127	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	24 pcs	0 pcs	24 pcs	\$2.40/pcs	\$57.60
24 x SEP 07 2018											



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PURCHASE ORDER

PO040899

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	181341	RBEM633V3000124-3	Nut -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	-	9/6/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
7	178185	RBEM632V3011101-1	Plier Half -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$11.25/pcs	\$90.00
8	177796	RBEM652V3002101-M-9	Bar Handle Nut -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$1.85/pcs	\$14.80

Grand Total: \$437.20



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PURCHASE ORDER PO040899

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/6/18 3:56 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(012322-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012322- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Sep-2018		Aman		040899				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3701-00-03-A Rev. 181846A	RBE350A94-3701-00-03-A 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 MIL-A-8625F	ANODIZE LOT	1	1	0	0	0
2	RB AN8516-1-PO Rev. 181727	RB AN8516-1-PO 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 IT IS KITS NOT SINGLE	BLACK-OXIDE CH	3	3	0	0	0
3	RBT18520-5 Rev. 182724	RBT18520-5 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	2	2	0	0	0
4	RBT18520-9 Rev. 181556	RBT18520-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
5	RBE350A94-2706-00-05 Rev. 181127	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
7	RBEM632V3011101-1 Rev. 178185	RBEM632V3011101-1 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2 MATERIAL TYPE 1018	ZINC CH	8	8	0	0	0
8	RBEM652V3002101-M-9 Rev. 177796	RBEM652V3002101-M-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.